Page 1

in 10's

Monday, October 18, 2010 1:02:55 PM & Item ID: D3580-1 Accept Setup Start **Revision ID:** Stop Item Name: Joggle Bracket **Start Date:** 10/18/2010 **Start Qty: 60.00 Cust Item ID: Required Date:** 10/26/2010 Req'd Qty: 60.00 Customer: Reference: Start Run Date/ 10 Tooling: Approvals: **Process Plan:** Date: Stop QC: SPC (Y/N): Date: Sequence ID/ Operation. Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description Qty Number | Stamp **Run Hours** Code Qty **Draw Nbr Revision Nbr** D3580 Rev B 0.00 FLOW WATER JET B10-10-90 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3580 Dwg Rev: 364. G50 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B10-10-20 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 QC 0.00 Memo Quality Control

W/O:			W	ORK ORDER CHAN	IGES					
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Part No	:	PAR #: esolution:	Fault Cate	egory:	NÇ	R: Yes' I	No DQA		Date:	
	, R	esolution:	Disposition	on:	QA	: N/C Clo	sed:		Date:	
NCR:		W	ORK ORD	ER NON-CONFORI	MANC	(NCR) ,			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Descriptio Chief Eng	ection B n	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
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Work	Order	II) 6	3042
Monday,	October 1	8, 2	2010	1:02:5.



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Insp.

2:55 PM -Item ID: D3580-1 Accept Setup Start **Revision ID:** Stop Item Name: Joggle Bracket **Start Qty: 60.00 Start Date:** 10/18/2010 **Cust Item ID:** Required Date: 10/26/2010 Req'd Qty: 60.00 **Customer:** Reference: Run Start **Approvals: Process Plan:** Date: Tooling: Date: Stop QC: ' Date: SPC (Y/N): Date; Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Work Center ID , Description **Run Hours** Code Qty Qty Number - Stamp 130 0.00 Spirololas Dobu 1st Small Fab Small Fab 0.00 Memo Small Fab Bend as per dwg D3580 using 1/8" offset die 140 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo aspois Quality Control

150

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

W/O:			W	ORK ORDER CHA	NGES					
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DATE	STEP	Description of NC	, ,,,,,	****	Section B	Ciara 9		cation	Approval	Approval
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Work Order ID 63042

Monday, October 18, 2010 1:02:55 PM



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Item ID:

D3580-1

Accept



Setup Start



Revision ID:

Item Name:

Joggle Bracket

Start Date:

Required Date: 10/26/2010

10/18/2010

Start Qty: 60.00

Req'd Qty: 60.00

Operation

Description



Cust Item ID:

Customer:

Reference:

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Process Plan: QC:

Date:

QC21- Final Inspection - Work Order Release

Date:

Tooling: SPC (Y/N):

Set Up/

Date:

Date:

Run Start

Stop

Stop



Sequence ID/

Work Center ID

160

Memo

Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

10/10/21)

Quality Control

0.00

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W/O:			WO	RK ORDER CHA	NGES					
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DATE	STEP	Description of NC		Corrective Action	Section B	Ciam 0	I	cation	Approvai	Approval
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Picklist Print

Monday, October 18, 2010 1:03:00 PM

Work Order ID: 63042

Parent Item:

D3580-1

Parent Item Name: Joggle Bracket



Start Date: 10/18/2010

Required Date: 10/26/2010

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev : A New Issue 07.06.25 EC

IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA	Pitii saasi ini ina	Purchased	\ No)		100	sf	94.8879	0.01	0.631579	-	3	
					•	•				tz_1	0-10-	20	

304/316 .050 Sheet

<u>Location</u>	Loc Qty	Loc Code	
MAT20	94.8879	·	
111743	6.55		(125)
112885	0.1679	1198	385
113062	40.17		
115389	48	-	

W/O:	· · · · · · · · · · · · · · · · · · ·		WO	RK ORDER CHANG	GES	<u> </u>				-
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Part No	:	PAR #:		ory:	•	es N	o DQ	\ :	 Date:	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORM	IANCE (N	CR)		****		
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section	on C	Chief Eng	QC Inspector
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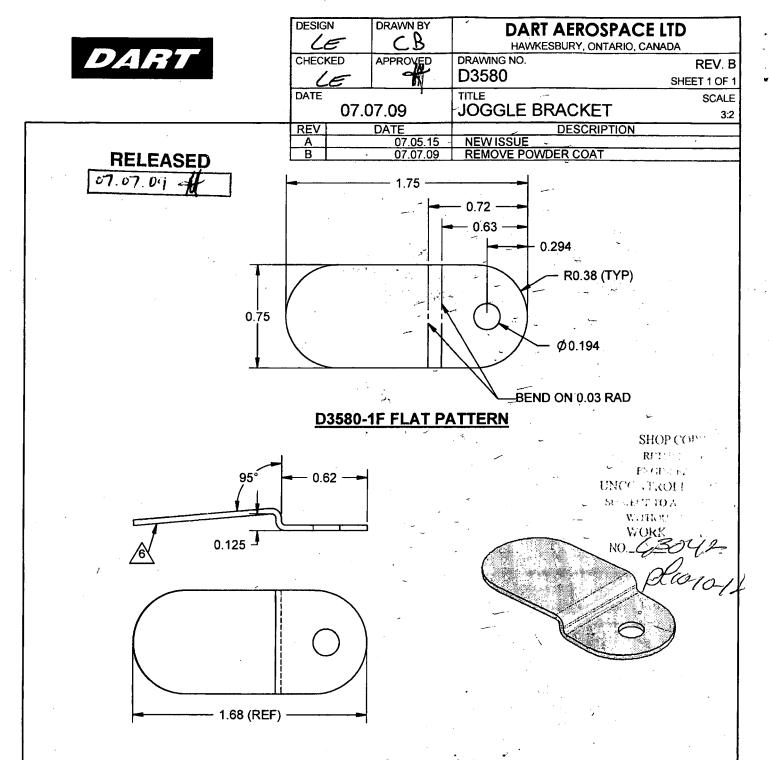
DART AEROSPACE LTD	Work Order:	430412
Description: Joggle Bracket	Part Number:	D3580-1
Inspection Dwg: D3580 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST.

		X	First Artic	·	_	otype		
	rawing nension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments
Q	0.194	+0.005/-0.001	.198	*		V 1802	-	
	1.75	+/-0.030	1,744	k		U		
	0.75	+/-0.030	742	7		V	-	
	0.294	+/-0.010	743	Æ		V-		
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				1				
Meas	ured by:		Audited by:			Prototype /	Approval:	N/A
	Date:	B	Date:	1000-7	$\overline{}$		Date:	N/A
	Date.	10-10-30	Date.	10.10.20	L			
Rev	Date	Change				Re	vised by,	Approved
Α	07.10.30	New Issue				KJ	/EC/DD	- 77

Dart Aeı	rospace	e Ltd							
W/O:			WORK ORD	ER CHANGES					
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						¥ ·			
Part No	:	PAR #:	Fault Category:	NO	CR: Yes	No DQ	A:	Date: _	·
	Re	esolution:	Disposition:	Q,	A: N/C C	Closed:		Date: _	
NCD.			WORK ORDER NON-	CONFORMANC	E (NC	R)			

	, WC	ORK OR	DER NON-CONFORMANCE	(NCR)			,
	C Description of NC		Corrective Action Section B		Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Chief Eng Corrective Action Section B Verification Section C Se



D3580-1 JOGGLE BRACKET

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
 PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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W/O:			WORK ORDER CHANGES						
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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				<u> </u>				,	
Part No:		PAR #:	Fault Category:	NCR: Ye	Date: _				
Resolution:			Disposition: QA: N/C Closed			Date:			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC	Corrective Action Section B			Verification	Approval	Approval			
		Section A	Initial Chief Eng			Section C	Chief Eng	Approval QC Inspector			
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